

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021798**Date Inspected:** 06-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Brett W Rice was present during the times noted above for observations relative to the work being performed at ZPMC.

Bay 14 East

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Zhong Yong Gang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SA-7005-001

Weld No: 001

Welder: 214945 and 044824

WPS-B-T-2231-ESAB

PCMK: SEG-3007G

Weld No: 008

Welder: 055564

WPS-B-T-2232-ESAB

PCMK: SEG-3007L

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

Weld No: 011
Welder: 055491
WPS-B-T-2232-ESAB

PCMK: DP-3167-001
Weld No: 149 and 150
Welder: 044790
WPS-B-T-2133-ESAB

PCMK: DP-3167-001
Weld No: 148 and 151
Welder: 051356
WPS-B-T-2133-ESAB

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Zhong Yong Gang.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

PCMK: SA-3067-001
Weld No: 004
WR: 20354
Welder: 216086
WPS-345-SMAW-2G(2F)-FCM-Repair-1

PCMK: SEG-3019P
Weld No: 217 and 218
WR: 20247
Welder: 050232
WPS-345-SMAW-1G(1F)-FCM-Repair-1

PCMK: SEG-3019AW
Weld No: 100
Welder: 050969, 215553, 044779, and 054013
WPS-B-P-2212-TC-U4b-FCM-1

PCMK: DP-3166-001
Weld No: 001, 002, and 003
Welder: 043661
WPS-B-P-2113-FCM-1

PCMK: SEG-3019AP
Weld No: 038

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

Welder: 037748

WPS-B-P-2214-TC-U4b-FCM-1

Bay 16

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Xu Tao.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: E5-SB25A-001

Weld No: 032~043, 048 and 049

Welder: 053753

WPS-B-T-2113

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Xu Tao.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: E2-SB24C-001

Weld No: 075~078 and 082~087

Welder: 201889

WPS-B-T-2132-ESAB

PCMK: E5-SB25C-001

Weld No: 032~043, 048, and 049

Welder: 210905

WPS-B-T-2133-ESAB

PCMK: W2-SB26-001

Weld No: 044~047 and 051~056

Welder: 201074

WPS-B-T-2132-ESAB

Bay 19

This QA Inspector observed the following work in progress for Bay 19.

ZPMC was using the Heat Straightening process.

ZPMC QC is identified as Xu Tao.

Welding variables recorded by QC appeared to comply with the approved Heat Straightening Procedure Specification (HSR). Listed below are the locations that were identified by this QA inspector.

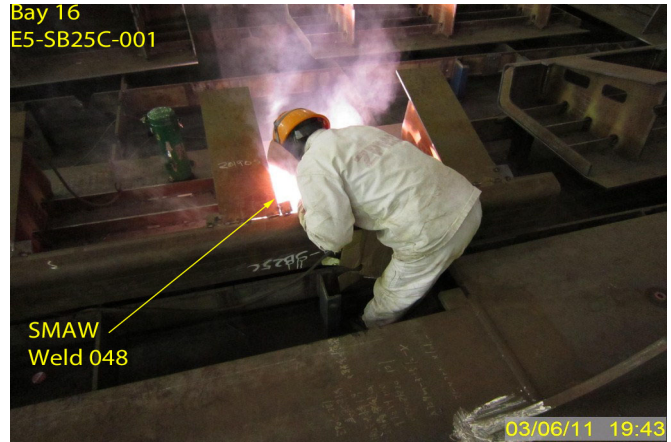
PCMK: BK-004A-013

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

HSR-1(B)-9501

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Rice,Brett	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
